

81056

March-07-12 2:25:11 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 07/03/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 21/03/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ

Date: 12/03/07 **Tooling:**

Date:

QC:

Date: _____ **SPC (Y/N):** _____

Date:

NR2

Draw Nbr	Revision Nbr
D2604	Rev B

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D2604 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

070 H02

110

QC2-Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81056

81056

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Item ID: D2604-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Console Side RH, 407 Console
Start Date: 07/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 21/03/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00							
130									
Brake NC	Memo	0.00							
Brake NC	Deburr if necessary Form as per Dwg D2604								
				SN 12/03/30					
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									

4

SN 12/03/30

4

4. 123-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 81056***81056***

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March-07-12 2:25:11 PM

Item ID: D2604-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Console Side RH, 407 Console
Start Date: 07/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 21/03/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
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160

QC

Memo

Quality Control

170	Identify as per dwg & Stock Location ST178	0.00							
-----	---	------	--	--	--	--	--	--	--

170

Packaging

Memo

Packaging

180	QC21- Final Inspection - Work Order Release	0.00							
-----	---	------	--	--	--	--	--	--	--

180

QC

Memo

Quality Control

4X ✓ M-12/03/30

(4X) SP12 03-30

12/4/12
CL 12/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

March-07-12 2:25:15 PM

Page 1

Work Order ID: 81056

81056

Parent Item: D2604-2

D2604-2

Parent Item Name: Console Side RH, 407 Console

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP D02.06.05Added alodine finish TSR 1290NG
IPP Rev:D 07-09-24 Now On Waterjet JLM Verified By:EC
IPP Rev:E 07-12-18 RevB as per dwg ECN1059 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	226.2284	1.3472	5.67242			
M2024T3S 040										**		12 03 28	
2024-T3 .040 sheet													

Location

Loc Qty

Loc Code

MAT022

226.228421

117684

26.318421

120196

59.41

120605

140.5

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Dart Aerospace Ltd

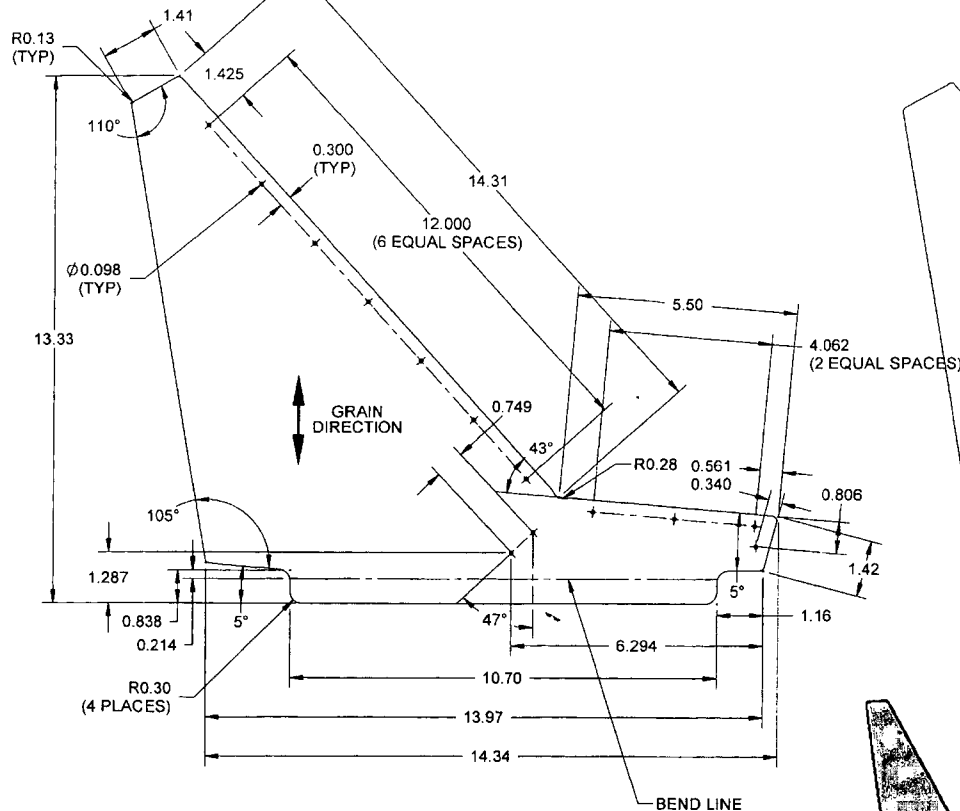
W/O:		WORK ORDER CHANGES					
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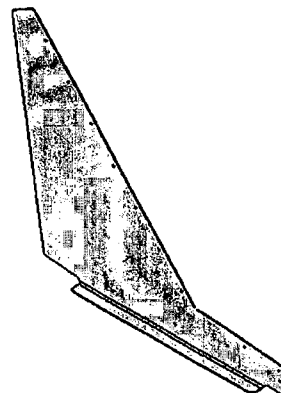
NOTE: Date & initial all entries



D2604-1F FLAT PATTERN

**D2604-1 CONSOLE SIDE (MAKE FROM D2604-1F)
(D2604-2 OPPOSITE)**

RELEASED
07.12.12



- NOTES:**
 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.36 lbs

B	ADD GRAIN DIRECTION, UPDATE DIMS. GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2604 WAS D206-547-23/24	BW	97.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.		D2604	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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